

# Work Order ID 58272

May 3, 2010 9:52:49 AM



Page 1

Item ID: D2991-1

Accept



Setup Start



Revision ID:

Item Name: Side Door

Stop



Start Date: 03/05/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*AP*

Date: *10-5-03*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2991

D

110

0.00



Purchasing

Purchasing

Memo

0.00

Purchasing

Issue P/O:

*11809*

Description: D2991-1 side door

Supplier: Delastek

Ship to delastek: Qty 2 D2992-1 Doubler batch:

*47743*

Certificate of Conformity and process sheet from Delastek

*Bl 10-5-03*  
*(1)*

120

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

*Ch 10/5/23*  
*(1)*



DELASTEK

**MATÉRIEL NON-CONFORME  
NE PAS UTILISER**

NO. RNC: *4754*

DATE: *22-Juin-2010*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 58272

May 3, 2010 9:52:49 AM



Page 2

Item ID: D2991-1

Accept



Setup Start



Revision ID:

Item Name: Side Door

Stop



Start Date: 03/05/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D2991

Door was Re works  
to element wire  
8/10/12/08

Pro →

140

Identify as per dwg & Stock Location: composites

0.00



Packaging

Memo

0.00

Packaging

ET 10-12-06

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/09

MF  
10-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2991-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 58272		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/12/08	110	Waves were found in outer side of Door (Gell coat surface) caused by the mold not conforming		- open NCR for Rework of <del>Door</del> Mold. N/A		N/A		S 10/12/08
		R.C		- Fix Door to conform to Dart spec specs. - band sand gel coat finish to remove waves + reprint	IT 10-12-08 	S 10/12/08		S 10/12/08

NOTE: Date & initial all entries

## Picklist Print

May 3, 2010 9:52:54 AM

Page 1

**Work Order ID:** 58272

**Parent Item:** D2991-1

**Parent Item Name:** Side Door

**Start Date:** 03/05/2010

**Required Date:** 13/05/2010

**Comments:** IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC  
IPP Rev:B 08-02-20 ECN 1096 DD verified by:EC

**Start Qty: 1.00**

**Required Qty: 1.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2991-1P		Purchased	No			110	Each	0.0000	1			

D2991-1P



SIDE DOOR

B58272



五

10-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# D2991-1/-2/-3 SIDE DOOR

## NOTES

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM = 3/8", A500 CORE-CELL OR DIVYCELL OR AIREX OR KLEGECELL  
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR  
USE MOLD DT8627 FOR D2991-2 SIDE DOOR  
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR  
DT8629 FOR D2991-2 SIDE DOOR  
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005  
9 OZ SATIN  
9 OZ SATIN  
FOAM  
FOAM STRIP  
9 OZ SATIN  
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)  
9 OZ SATIN  
RESIN (35-45% BY WEIGHT)  
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: NONE
- 13) WEIGHT: 9 lbs TYP

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 58272  
2010-5-03

RELEASED  
2009-10-30

D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.09.26		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2991	REV. D SHEET 1 OF 5
TITLE SIDE DOOR	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
2009-10-30  
mjd

**D2991-1 SIDE DOOR**

DESIGN	<i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>CP</i>		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	<i>MS</i>	D2991	SHEET 2 OF 5
APPROVED	<i>AN</i>	TITLE	SCALE
DE APPR.	<i>MS</i>	SIDE DOOR	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

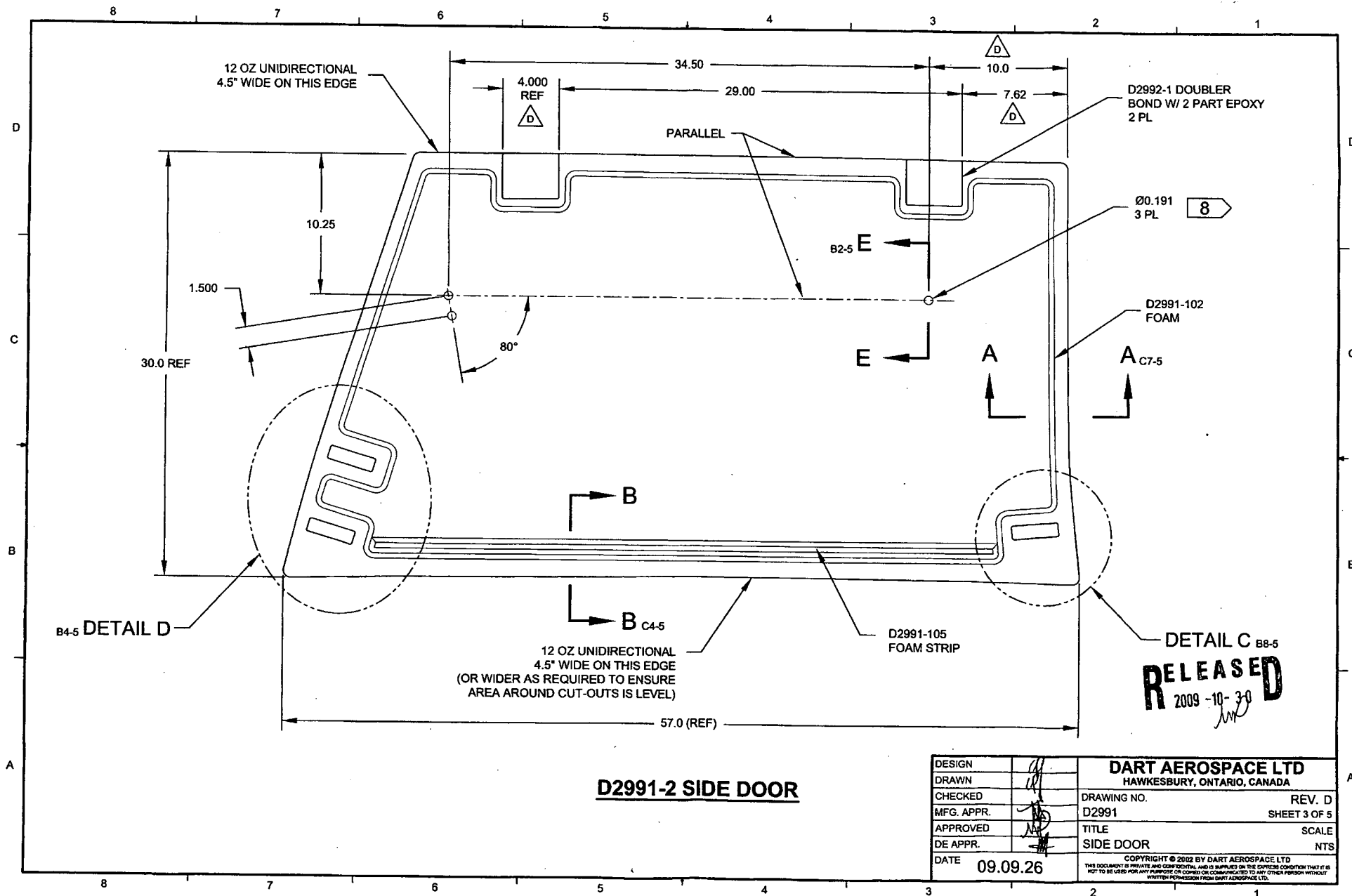
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

W10 58272



# **D2991-2 SIDE DOOR**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2991	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	09.09.26	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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**RELEASED**  
2009-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

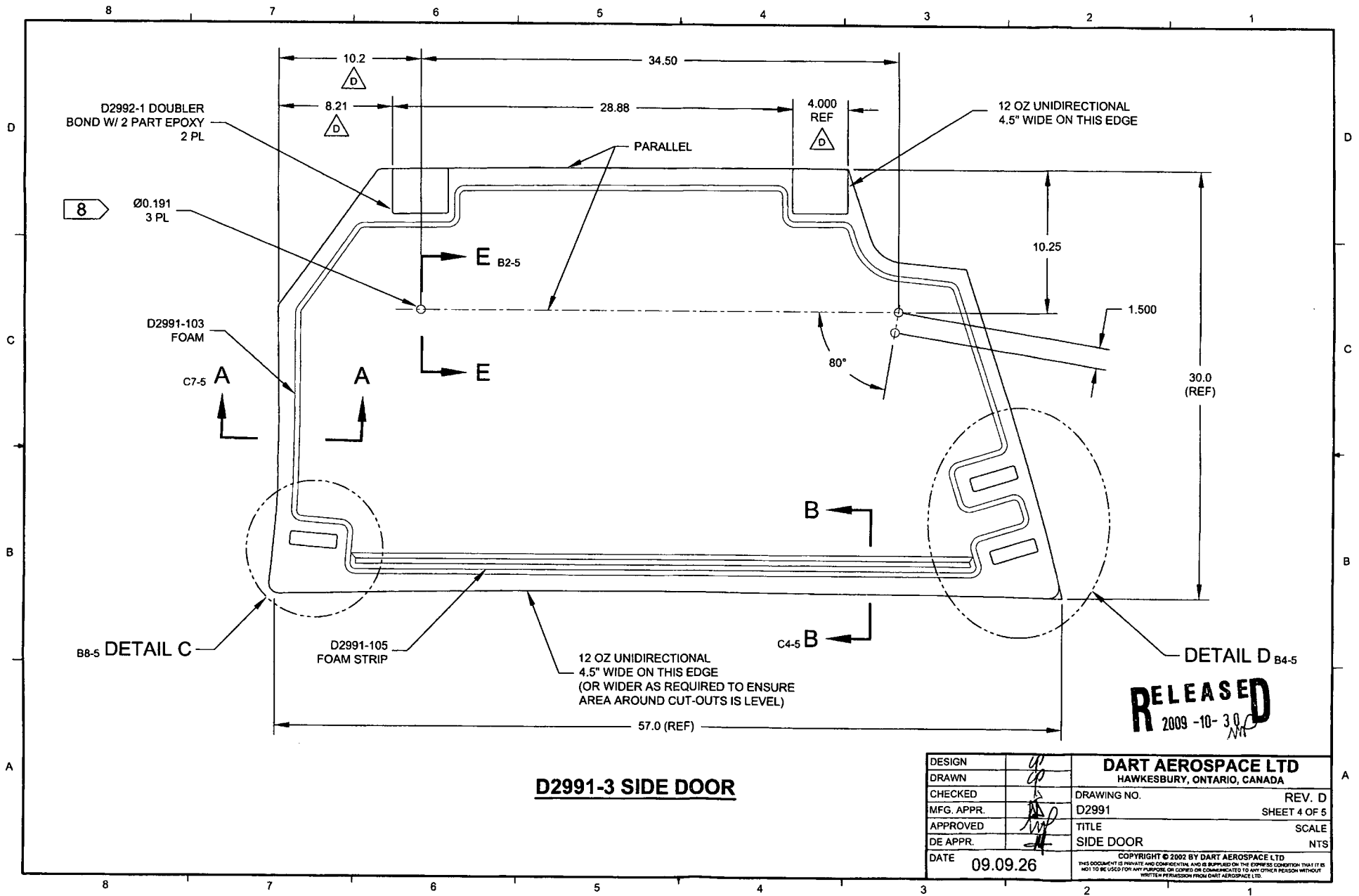
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

W/058272



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

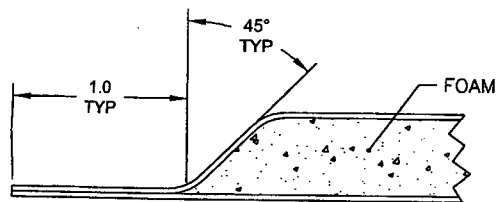
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

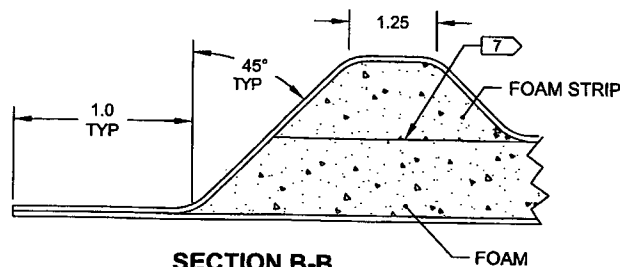
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

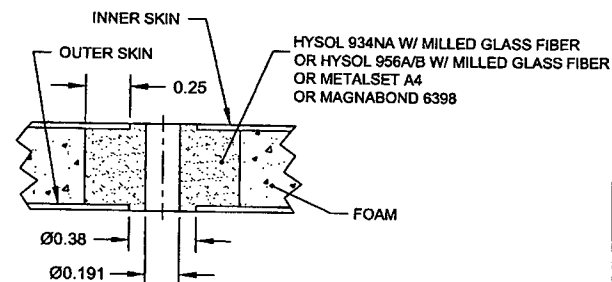
W1058272



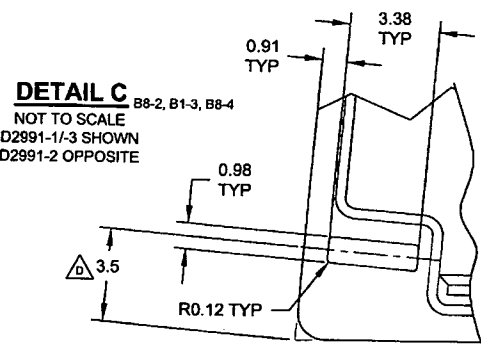
**SECTION A-A**  
NOT TO SCALE  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE  
C7-2, C2-3, C7-4



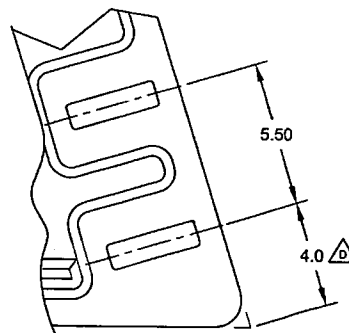
**SECTION B-B**  
ONE EDGE ONLY  
NOT TO SCALE, VIEW ROTATED  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE  
B4-2, B5-3, B4-4



**SECTION E-E**  
TYPICAL Ø0.191  
HOLE DETAIL  
NOT TO SCALE  
D6-2, D3-3, C6-4



**DETAIL C**  
NOT TO SCALE  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE  
B8-2, B1-3, B8-4



**DETAIL D**  
NOT TO SCALE  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE  
B1-2, B8-3, B1-4

**RELEASED**  
2009-10-30  
1/14

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2991	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	09.09.26	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577

\*\*\*OUTSTANDING PO REPRINT\*\*\*

Purchase Order ID PO11819

Purchase Order Date 5/04/10

PO Print Date 9/22/10

Page Number 1 of 1

Order From :

VU-DEL003

DELASTEK INC  
2699 5E AVENUE, LOCAL C.P 123

GRAND-MERE, QC G9T 5K7  
CA

Contact Name		Buyer	Brigitte Golden
Vendor Phone	819 533 5788	Requisition Nbr	
Vendor Fax	819 533 3494	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	USD
		FOB	

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Unit Price	Extended Price
----------	------------------------------------------------	------------------------	----------------------	---------	------------	----------------

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
2	D2991-1P	SIDE DOOR	8/09/10 Yes	1.00 Each	Purolator ground	\$700.0000	\$700.00

Special Inst: DWG: D2991, REV: D  
B# 58272  
DKC134-0066

Line Total: \$700.00

Outstanding PO Total: \$700.00

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Change Nbr: 6

Change Date: 9/22/10

*C.L.L.*  
No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	33764
Customer #	DART US

Telephone: (819) 533-5788  
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
05/07/2010	03/05/2010	14003	Brigitte Golden		PO11819		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKA-SAV-AERONA UTIQUE	Line 3 D2991-1 Side Door, Scrap door DKC134-0066			
			U de M : Each				

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

Accepted by: \_\_\_\_\_  
Quality department AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mercredi, 2010-05-05 10:20:04  
Utilisateur: marc dubé

## Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: SIDE DOOR N. D2991-1
Numéro Job	: 26265	Numéro Article	: DKC134-0066
Numéro Soumission	: 3756	Numéro Dessin	: D2991
Numéro B.A.	:	Projet Numéro	: DK-134
Cette fois	: 2010-05-05 No. B.V. :	Révision dessin	: D
Prsht Rev.	: NC	Matériel	: Composites
Prem. fois	: - - Type :	Date Dûe	: 2010-05-12
Job précédente	: 25220	Qté:	1 Udm: UNITE

Écrit par : \_\_\_\_\_  
Vérifié & Approuvé par : \_\_\_\_\_  
Commentaires : N. de pièce client: D2991-1

Process Sheet Rév.: 00 Création du premier dans DKA à partir de la  
Rév.: 00 De DKC

Inscrire le N° de  
Série : B58272 Sur la  
pièce

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 AAC0854 Frekote #700-NC

Commentair Qty.: 0.025 UNITE(s)/Unit Total : 0.025 UNITE(s)

2.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DKO-0094 laisser sécher pendant 3 heures selon le QSI-006 et IG 0009.

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

1-27406-1

Commentair Qty.: 0.040 UNITE(s)/Unit Total : 0.040 UNITE(s)

4.0 AMB0286 Catalyst N° DDM-9

1-22176-1

Commentair Qty.: 0.0040 GALLON(s)/Unit Total : 0.0040 GALLON(s)

5.0 AAC1606 UN2055 styrene monomere ST

Commentair Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)

6.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation et l'application du Gel coat selon IG0019, et diluer à l'aide de 5% de UN2055 styrene monomere ST

Date: 11-5-10 Sceau: Temps Début: \_\_\_\_\_ Temps Fin: \_\_\_\_\_

Date: Mercredi, 2010-05-05 10:20:05  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 26265

Nom Dessin: SIDE DOOR N. D2991-1  
Numéro Article: DKC134-0066

Numéro Job:



# Séq.: Machine ou Opération: Description :

7.0 GEL COAT Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'application du gel coat sur le moule N° DKO-0094 selon IG 0019

Date: 11-5-10 Sceau:



NIA déjà dans  
seq 60  
NG 11/01/2010

8.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)

9.0 AC0884 Wrightlon 5200 Bleu P3

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

10.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

11.0 AC0943 Stretchlon 200 poche à vide Vert

Commentair Qty.: 18.00 PIED(s)/Unit Total : 18.00 PIED(s)

12.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 7.3 VERGE(s)/Unit Total : 7.3 VERGE(s)

13.0 AMB0349 Fiberglass 12 oz Unidirectional

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)

14.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

15.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.














Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 4-9-09 Sceau:


















Date: Mercredi, 2010-05-05 10:20:05  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: SIDE DOOR N. D2991-1	
Numéro Job: 26265		Numéro Article: DKC134-0066	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
16.0	AMB0212	Résine (411B7530) 411-350 promo. 75min. <b>1-27342-1</b>	
Commentair Qty.: 0.400 KILOGRAMME(s)/Unit		Total : 0.400 KILOGRAMME(s)	
17.0	AMB0286	Catalyst N° DDM-9 <b>1-22176-1</b>	
Commentair Qty.: 0.0020 GALLON(s)/Unit		Total : 0.0020 GALLON(s)	
18.0	PREP-GENERAL	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs			
Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.			
Date: <b>11-5-10</b> Heure Début: _____ Heure Fin: _____ Sceau:  			
19.0	LAMINAGE	Faire le laminage	
			
Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs			
À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DKO-0094 et ensuite imbiber un pli de tissu 9.7 oz.			
Recommencer l'opération pour le deuxième pli.			
Date: <b>11-5-10</b> Heure Début: _____ Heure Fin: _____ Sceau:  			
20.0	BAGGING	Faire le bagging sur la pièce	
			
Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs			
Installer la poche à vide selon IG 0012.			
Laisser sécher pendant 4 heures minimum.			
Date: <b>11-5-10</b> Sceau:  			
Curing début: <b>3:20</b> Curing Fin: <b>8:00</b>			
21.0	AAC1611	Polybond B46F	
Commentair Qty.: 0.143 KIT(s)/Unit		Total : 0.143 KIT(s)	
22.0	DKC134-0062	Foam Core N° D2991-101 ( Porte D2991-1) <b>26401</b>	
Commentair Qty.: 1 UNITE(s)/Unit		Total : 1 UNITE(s)	








Date: Mercredi, 2010-05-05 10:20:05  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: SIDE DOOR N. D2991-1	
Numéro Job: 26265		Numéro Article: DKC134-0066	
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
	Faire le laminage du dernier pli de 9.7 oz.		
	Date: _____ Heure Début: _____ Heure Fin: _____ Sceau:  		
29.0	BAGGING	Faire le bagging sur la pièce	
			
Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
Faire la poche à vide selon IG 0012			
Laisser sécher pendant 4 heures minimum.			
	Date: <u>31-5-10</u> Heure Début: _____ Heure Fin: _____ Sceau:  		
	Curing Début: <u>3:20</u> Curing Fin: <u>8:00</u>		
30.0	DÉMOULAGE.	Démoulage	
		 	
Commentair Setup: 0.00Hrs/ Run: 5.0000Hrs Total Run : 5.0000Hrs			
Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ". Selon l'instruction générale de fabrication N° IG 0018			
	Date: <u>1-6-10</u> Sceau:   RNC: 4754 		
31.0	TRIMAGE	Trimage / Rivetage	
			
Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs			
À l'aide du gabarit N° _____ trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.			
Percer les " Latch " et les trous de penture selon le dessin N° D2991.			
	Date: _____ Sceau: _____		
32.0	AAC0205	COLLE HYSOL EA934NA	
Commentair Qty.: 0.15 KIT(s)/Unit Total : 0.15 KIT(s)			
33.0	AAC1540	Fibre de verre Miapoxy 66	
Commentair Qty.: 0.0037 GALLON(s)/Unit Total : 0.0037 GALLON(s)			

Date: Mercredi, 2010-05-05 10:20:05  
Utilisateur: marc dubé

## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE LTD		<b>Nom Dessin:</b> SIDE DOOR N. D2991-1	
<b>Numéro Job:</b> 26265		<b>Numéro Article:</b> DKC134-0066	
<b>Numéro Job:</b>			
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>	
34.0	TRIMAGE	Trimage / Rivetage	
			
<b>Commentair</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
À l'aide du Gabarit N° _____ Percer les 3 trous de 3/8" Dia.			
À l'aide d'une clé Allen et en faisant bien attention de ne pas abimer les Skins de la pièce, venir faire un dégagement de 7/8" Dia dans le Foam Core entre les Skin intérieur et extérieur.			
À l'aide de masking Tape, masquer le trou de la skin extérieur.			
À l'aide d'un mélange 10:1 de résine Hysol EA934NA / Fibre courte Miapoxy 66 et d'une seringue, venir remplir les dégagements de 7/8" Dia préalablement fait dans le foam Core.			
Laisser sécher.			
Date: _____ Sceau: _____			
35.0	TRIMAGE	Trimage / Rivetage	
			
<b>Commentair</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
À l'aide du gabarit N° _____ Repercer les 3 trous de 0.191" Dia.			
Date: _____ Sceau: _____			
36.0	AAC0205	COLLE HYSOL EA934NA	
<b>Commentair</b> Qty.: 0.13 KIT(s)/Unit Total : 0.13 KIT(s)			
37.0	AAC1681	N° D2991-2, Doubler	
<b>Commentair</b> Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)			
38.0	ASSEMBLAGE	Assemblage mécanique	
			
<b>Commentair</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
À l'aide de l'adhésif N° Hysol EA934NA, assembler le doubler N° D2992-1 sur la pièce de composite selon le dessin.			
Date: _____ Sceau: _____			
39.0	AAC1021	Dupont Primer N° 7704S	
<b>Commentair</b> Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s)			

Date: Mercredi, 2010-05-05 10:20:05  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 26265

Nom Dessin: SIDE DOOR N. D2991-1  
Numéro Article: DKC134-0066

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
40.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s)

41.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon I.G. 0008 et la fiche technique.

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_ # de fiche de mélange: \_\_\_\_\_

42.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection selon le dessin N° D2991

Date: \_\_\_\_\_ Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_

43.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'emballage des pièces.

Quantité: 1 Date: 22-06-10 Sceau: \_\_\_\_\_

**Inscrire le N° de  
Série : B58272 Sur la  
pièce**

